

Date: Monday, 29/09/2008 11:54:58 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOAT WEB
<b>Job Number</b> : 42319	
<b>Estimate Number</b> : 10791	
<b>P.O. Number</b> :	<b>Part Number</b> : D3282041
<b>This Issue</b> : 29/09/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3282 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 42314	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/10/2008 <b>Qty:</b> <u>5</u> <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 08.9.29</u>	
<b>Comment</b> : Est Rev:B 05.09.23 Procedure change KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D2792130	EXTRUSION
-----	----------	-----------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2792-130 Extrusion 33518

Identify as D3282-1

RT 08-10-01

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3282.

2- inspect for surface damage as per QSI0018

RT 08-10-01

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 &amp; Dwg D3282

2-Deburr

RT 08/10/01

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

RT 08/10/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 29/09/2008 11:54:58 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 42319

Part Number: D3282041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 08/10/01

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



AWM 8-10-3



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

④ 17-0-3

8.0	D32831	Doubler
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

039163

②

M 7-10-6

9.0	MS20470AD47	Rivet, Universal Head
-----	-------------	-----------------------



Comment: Qty.: 57.0000 Each(s)/Unit Total : 285.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M107242

②30

M 7-10-6

10.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
------	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web

A/RN/ALPS-3 M103674

④ M 7-10-6

11.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

⑤ 08/10/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 29/09/2008 11:54:58 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 DArt Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 42319

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: LG-

(4)

W

8-12-6

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 840-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42319
<b>Description:</b> Float Web		<b>Part Number:</b> D3282-041
<b>Inspection Dwg:</b> D3282	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

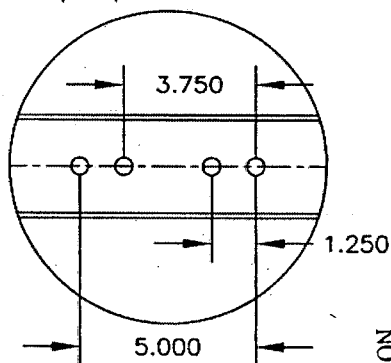
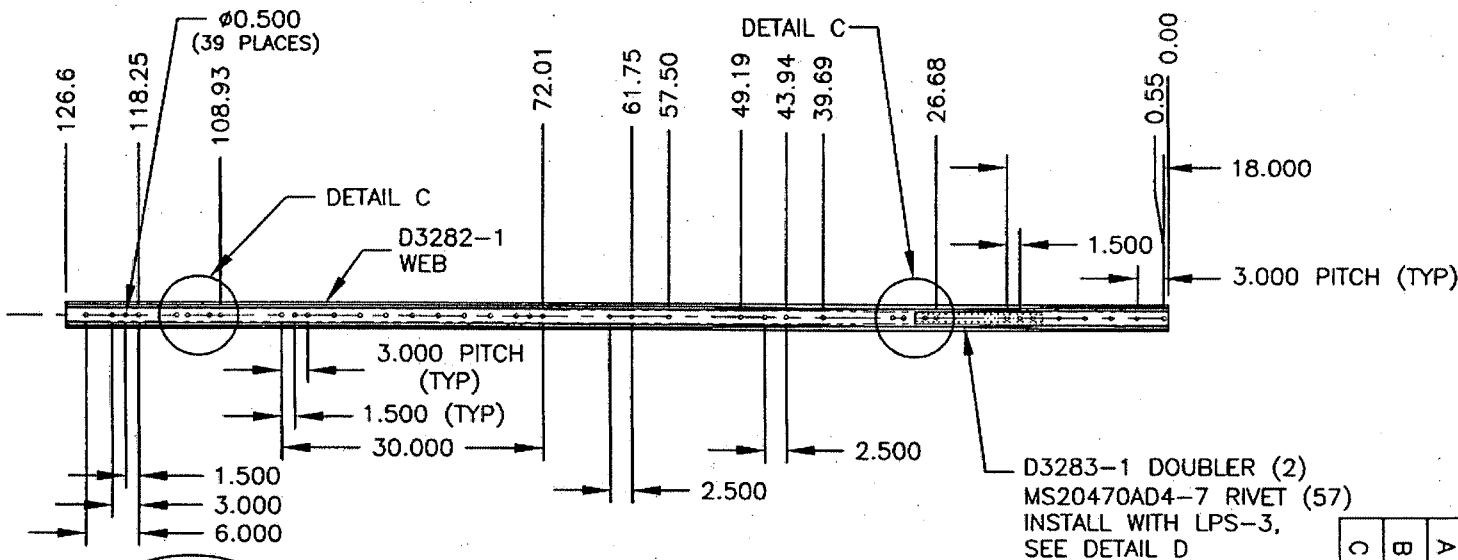
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.6	/			
1.500	+/-0.010	1.500	/			
3.000	+/-0.010	3.000	/			
6.000	+/-0.010	6.000	/			
1.250	+/-0.010	1.250	/			
30.000	+/-0.010	30.000	/			
1.500	+/-0.010	1.500	/			
72.01	+/-0.030	72.01	/			
61.75	+/-0.030	61.75	/			
57.50	+/-0.030	57.5	/			
49.19	+/-0.030	49.19	/			
43.94	+/-0.030	43.94	/			
39.69	+/-0.030	39.69	/			
26.68	+/-0.030	26.68	/			
0.55	+/-0.030	.540	/			
1.970	+/-0.010	1.970	/			
2.38	+/-0.030	2.380	/			
0.05	+/-0.030	.045	/			

<b>Measured by:</b> J.P.	<b>Audited by:</b> J.L.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/10/01	<b>Date:</b> 08/10/01	<b>Date:</b>	N/A

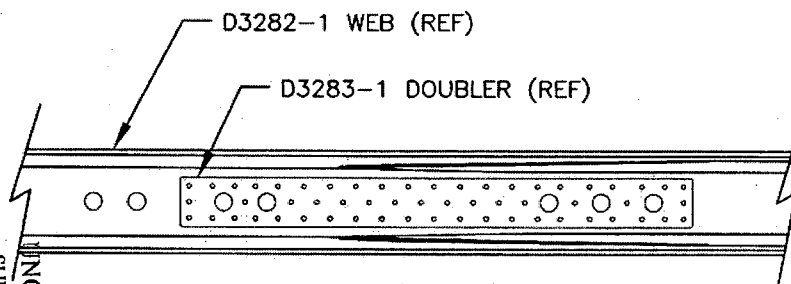
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		TITLE	FLOAT WEB, 206L/407	SHEET 1 OF 2
				SCALE 1:20
A	04.05.05	NEW ISSUE		
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS		
C	05.08.09	REMOVE D3390-1, NOW MACHINED		



**DETAIL C**  
SCALE 1:5  
RIVET HOLES NOT SHOWN  
FOR CLARITY



**DETAIL D**  
SCALE 1:5

NO. 42821  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

**D3282-041 FLOAT WEB**

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

RELEASED

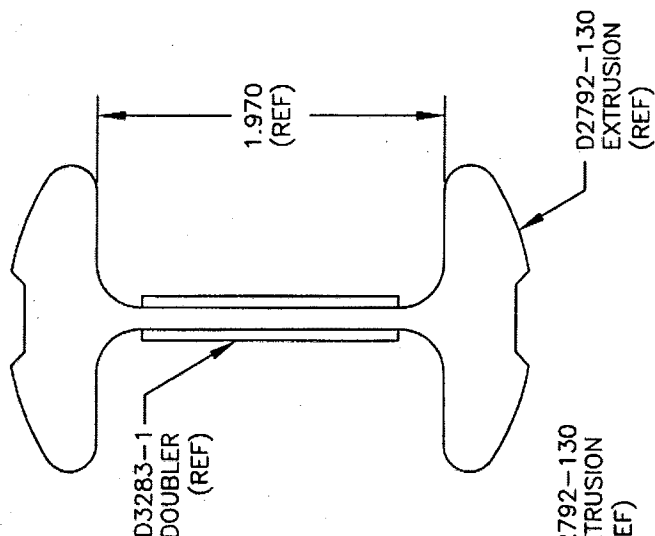
05.09.12



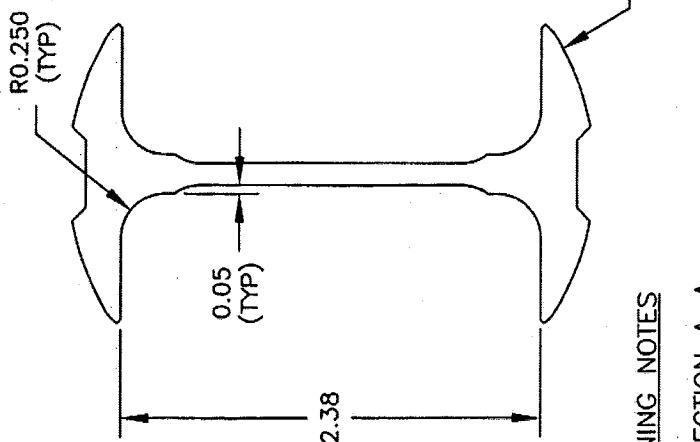


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		TITLE	FLOAT WEB, 206L/407	SHEET 2 OF 2
				SCALE 1:20

## SECTION B-B



## SECTION A-A



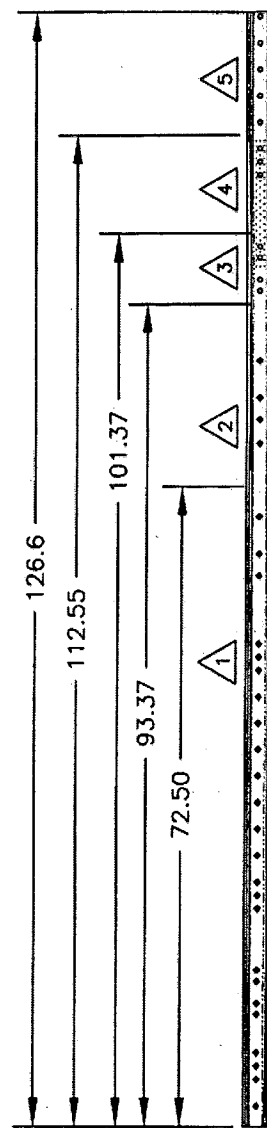
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42319

### D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A  
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1.  
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS

RELEASED

05.09.12



Copyright © 2004 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.